

Date: Today 11/18/2005 3:18:16 PM  
User: Linda Lacelle

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 24830 - 2		
Estimate Number	: 10533		
P.O. Number	: N/A	Part Number	: D2573
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Number	: D2573 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 24434	Material	: N/A
Written By	: See comment below	Due Date	: 12/20/2005 Qty: 12 Um: Each
Checked & Approved By	: See comment below		
Comment	: Est: H02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ		
Additional Product			
Job Number			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B04833 X4	
			J.G / PV 06/01/09 4
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: D4831 Double check by: EN 06/01/09	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks N/A 5-Tumble to remove sharp edges.	-M&G 06/01/09 J.G 06/01/09
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	J.G 06/01/10 4

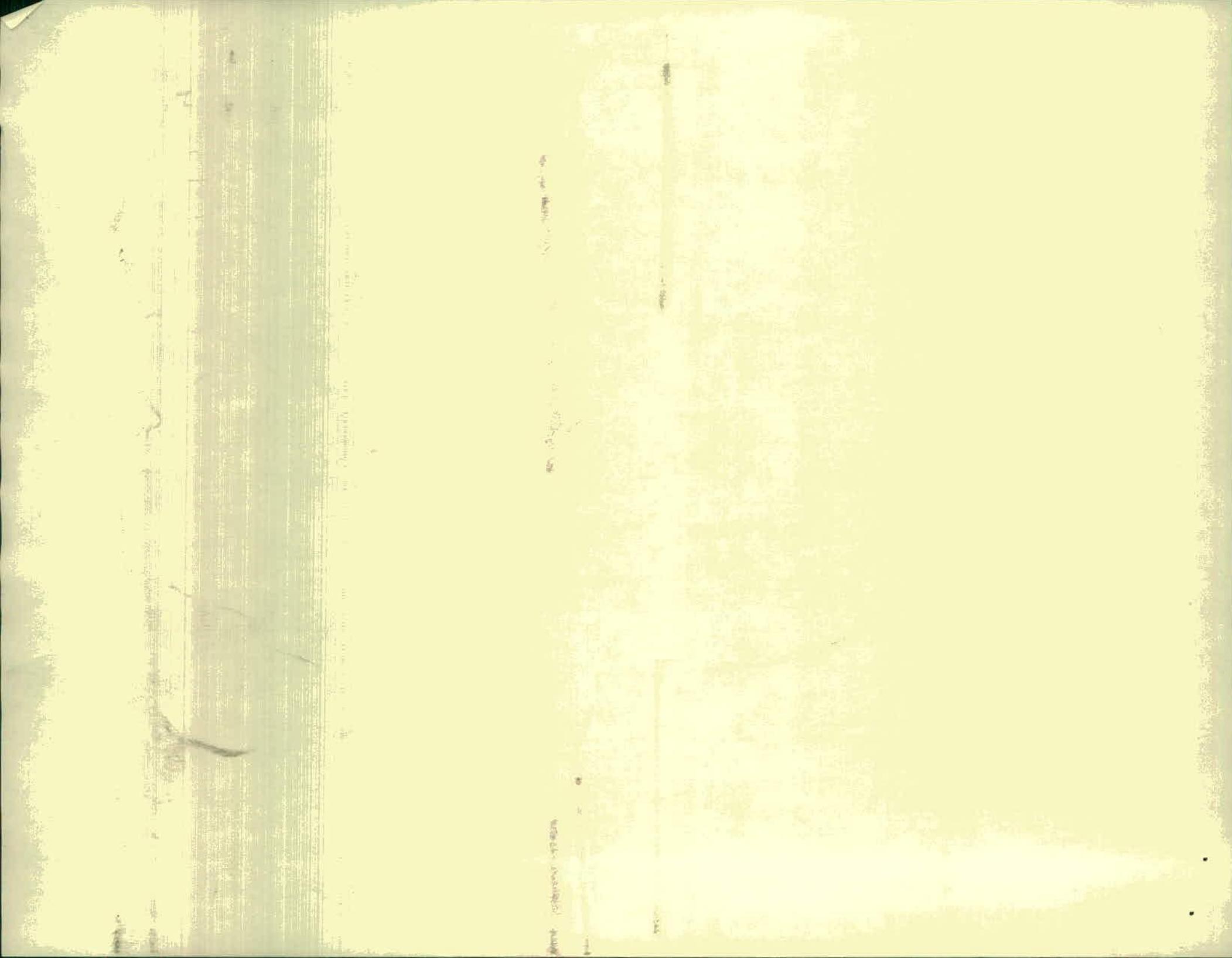


W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



Day, 11/18/2005 3:18:16 PM

Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24839

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

5.G 06/01/10

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.G 06/01/10

4

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

BC 06-01-10

4

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-11

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.0,5.1) as per QSI 005 4.3

M 06 01 16 4

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F 06/01/17 4

9.0 PACKAGING1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 374

F 06/01/17 4

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

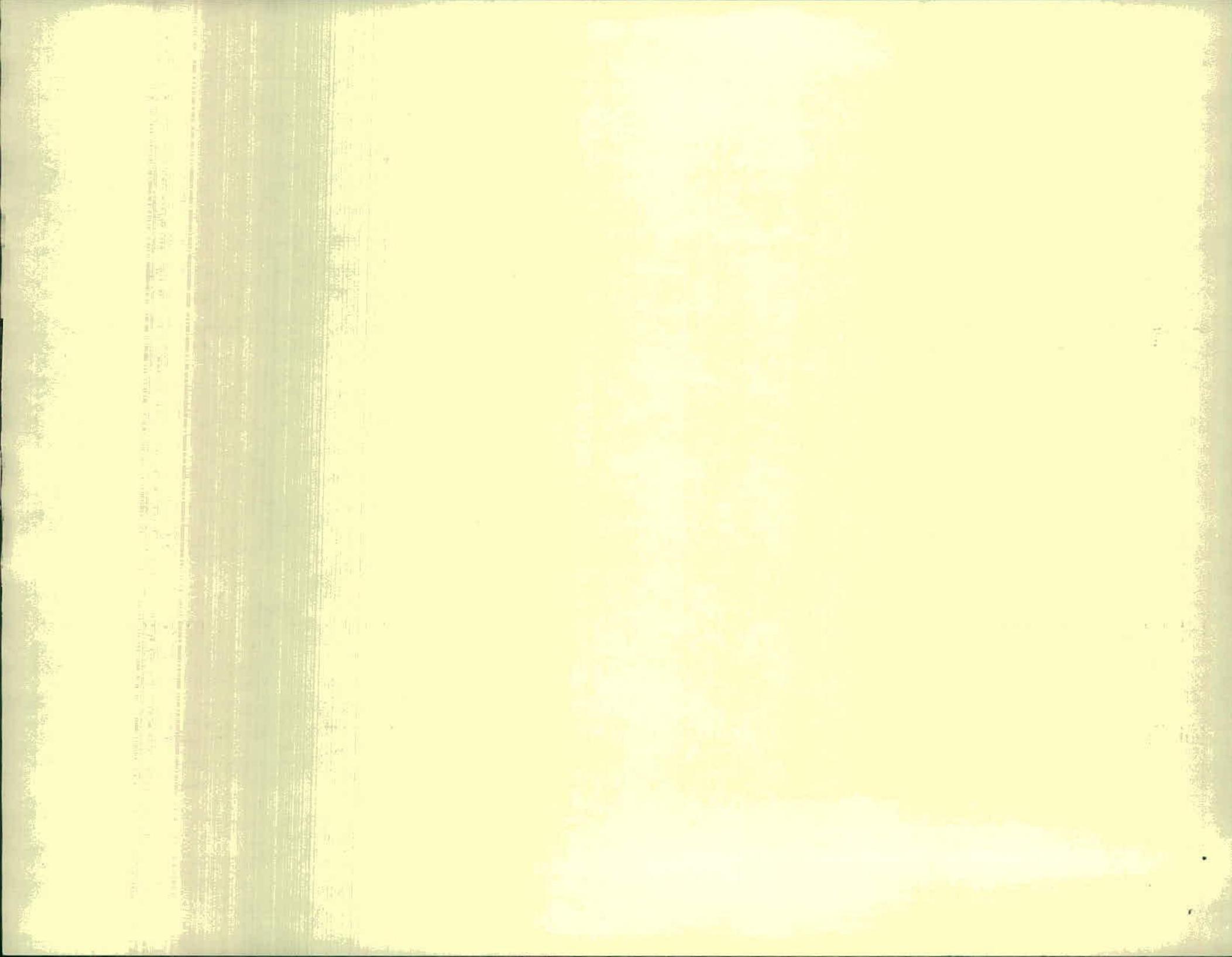
5 ac 06/01/18 D



D 06/01/18

Job Completion





AEROSPACE LTD	Work Order:	
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

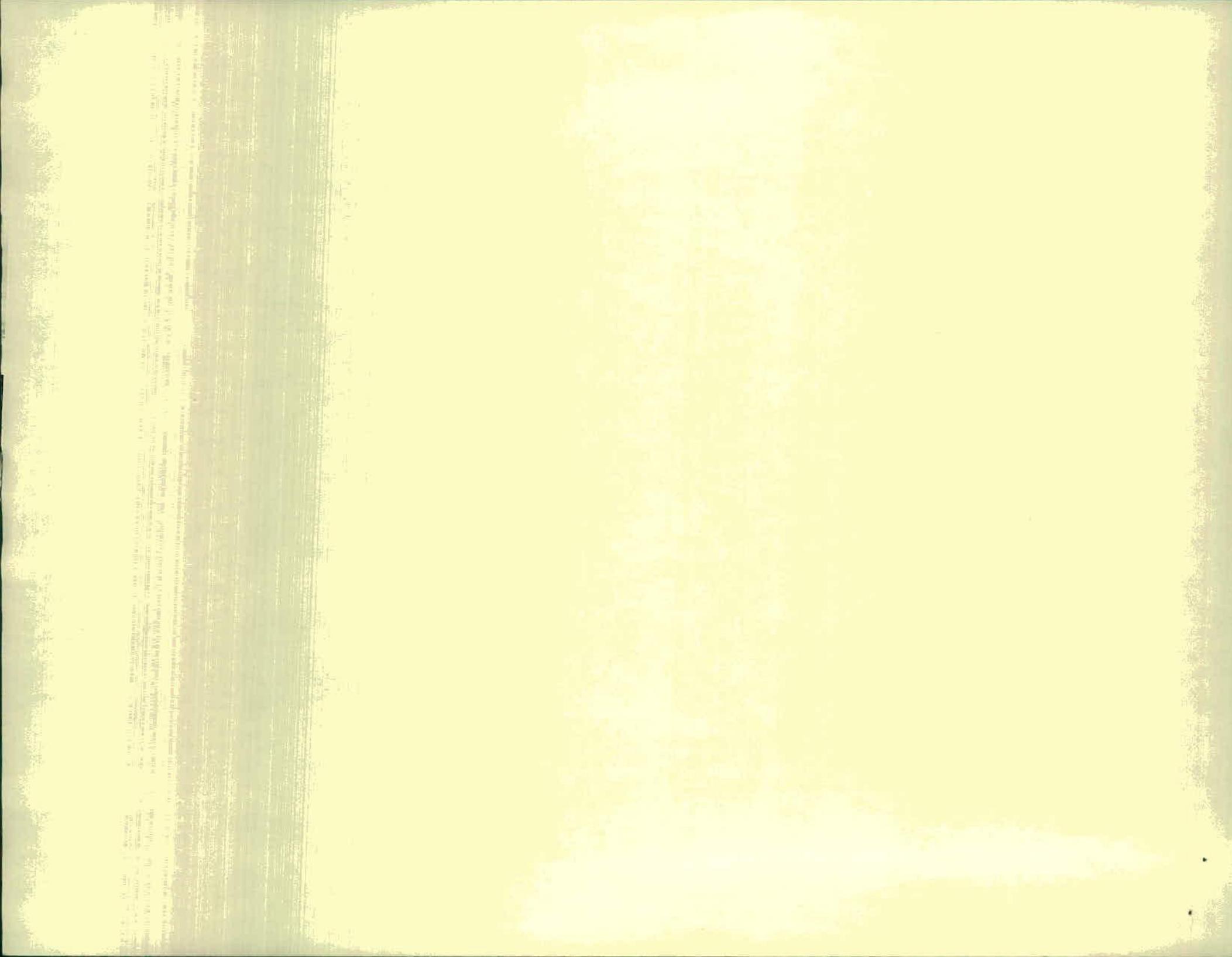
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	✓	✓	✓	✓	
B	1.745	1.755		1.746	1.751	1.752	1.751		
C	3.495	3.505		3.495	3.502	3.501	3.501		
D	1.745	1.755		1.746	1.750	1.752	1.751		
E	7.990	8.010		8.002	8.003	8.002	8.003		
F	0.490	0.510		0.500	0.507	0.503	0.508		
G	0.257	0.262	DT8683	0.257	✓	✓	✓	✓	
H	0.375	0.380	DT8684	0.376	✓	✓	✓	✓	
I	0.490	0.510		0.498	0.507	0.503	0.502		
J	1.174	1.184		1.179	1.179	1.180	1.180		
K	0.558	0.578		0.564	0.578	0.565	0.566		
L	1.174	1.184		1.170	1.182	1.180	1.180		
M	1.365	1.375		1.371	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.501	2.500		
O	4.119	4.129		4.127	4.125	4.121	4.122		
P	0.115	0.135		0.131	0.132	0.126	0.127		
Q	0.115	0.135		0.120	0.128	0.133	0.135		
R	0.240	0.260		0.255	0.255	0.248	0.252		
S	0.115	0.135		0.134	0.135	0.128	0.124		
T	0.178	0.198		0.1875	0.185	0.185	0.185		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		0.247	0.246	0.242	0.242		
W	0.115	0.135		0.116	0.135	0.133	0.130		
X	0.308	0.313							
Y	0.760	0.765							
Z	0.352	0.372		0.365	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.635	0.631	0.633	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.260	0.258	0.249		
AE	1.500	1.520		1.516	1.5066	1.508	1.511		
AF	0.115	0.135		0.118	0.128	0.125	0.130		
AG	0.240	0.280		0.255	0.270	0.270	0.255		
AH	0.240	0.260		0.257	0.250	0.255	0.255		
AI	2.000	2.020		2.000					
AJ	0.023	0.043							
Accept/Reject									

Measured by:	<i>RG</i>	Audited by:	<i>RG</i>
Date:	<i>06-01-10</i>	Date:	<i>06-01-10</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JLM</i>

RELEASED  
05.12.05



## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No : 0024839  
 Project Name : D2573  
 Project For : WK550  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2573  
 Description : Saddle, Aft, Out  
 Manufactured : Yes  
 Amount Billed : 12  
 Amount Done : 0  
 Start Date : 11-17-05  
 Est Finish Date : 12-20-05  
 Act Finish Date :  
 Drawings Req'd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
Overhead Hours	0.00	0.00	0.00		
Overhead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
 Burden	 0.00	 0.00	 0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

